

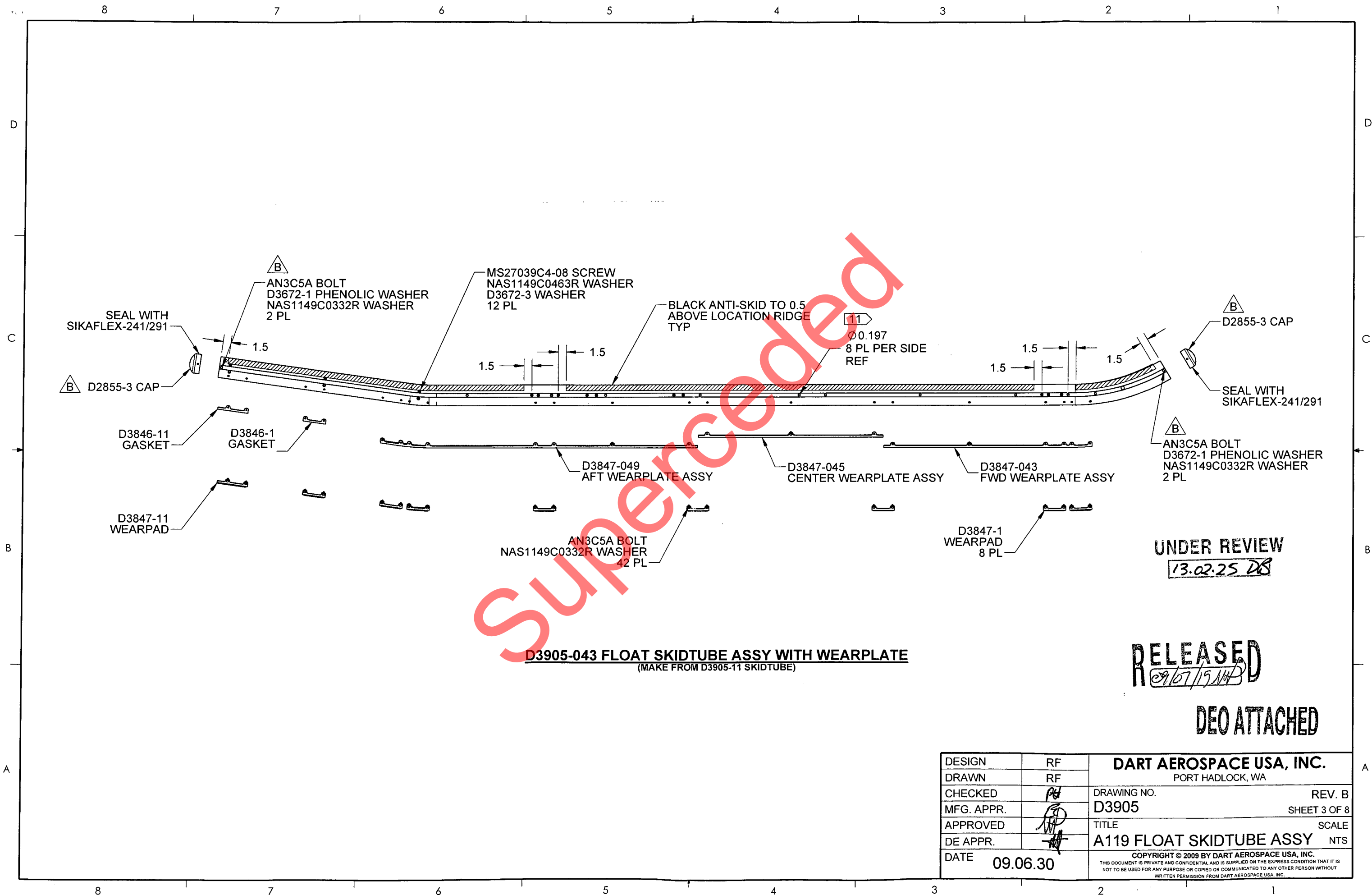
D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3905-041 = 40.7 lbs
D3905-043 = 47.0 lbs
D3905-045 = 47.3 lbs
 - 8) WELD PER DART QSI 004
 - 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
 - 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
 - 11) INSERT D3492-045 PLUG ASSY INTO $\phi 0.197$ HOLES (BOTH SIDES OF TUBE)
 - 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL $\phi 0.297$ HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.

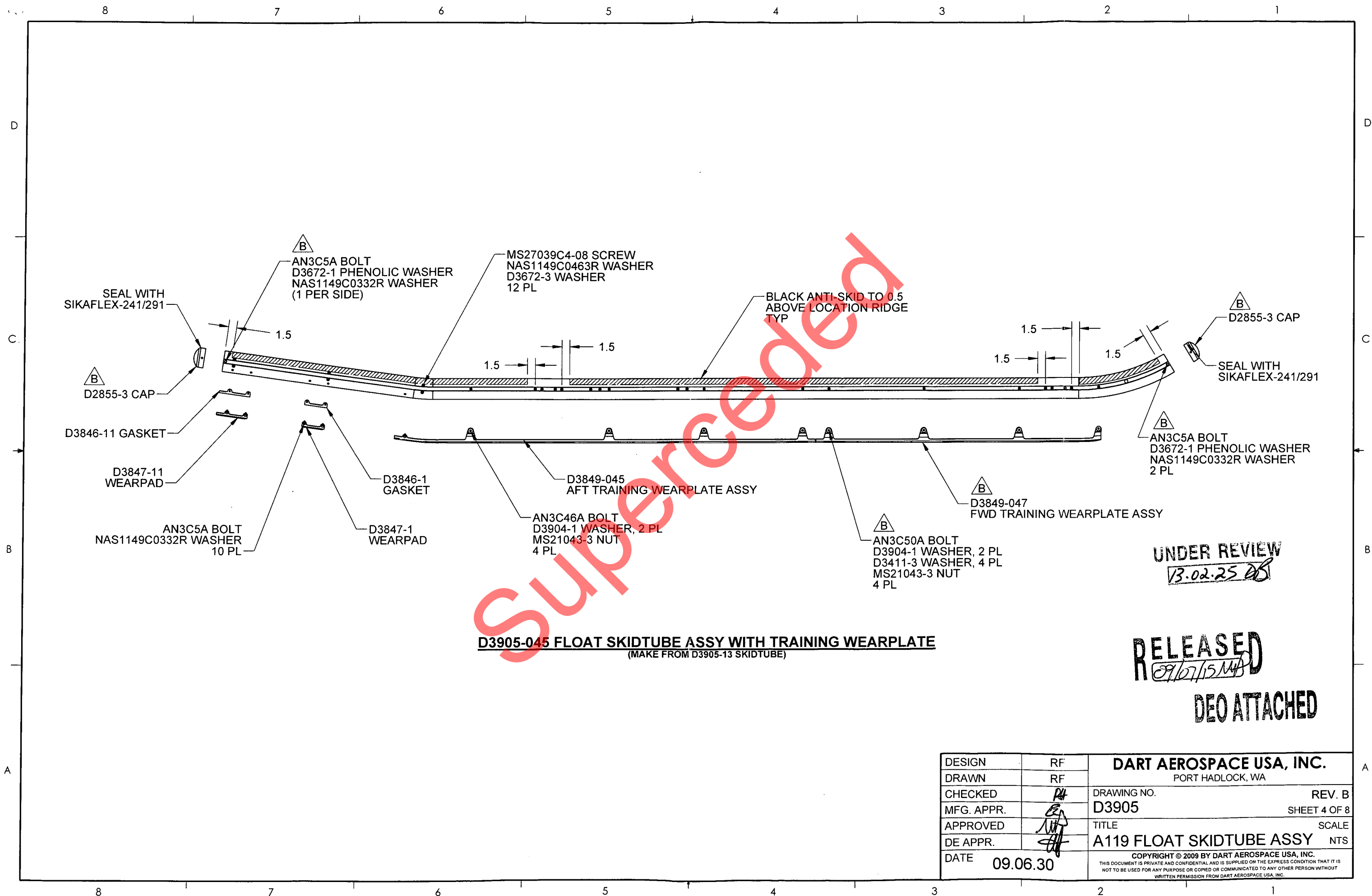
ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	8	1	1	D3846-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-047	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
31			16	D3411-3	WASHER
41	42	42	10	ALS4-1032-130	INSERT
42	46	46	14	AN3C5A	BOLT
43			4	AN3C46A	BOLT
44			4	AN3C50A	BOLT
45	46	46	10	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW

UNDER REVIEW
13/02/25
new fastener, fwd cap
RELEASED
09/07/15
DEO ATTACHED

B	REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A6-5, A5-6, C5-7, C3-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); $\phi 0.313$ WAS $\phi 0.328$ (B2-5, B2-6, C2-7, A8-7 & D7-8), REVISED NOTE IV (ZN A8-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3905	SHEET 1 OF 8
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 3 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

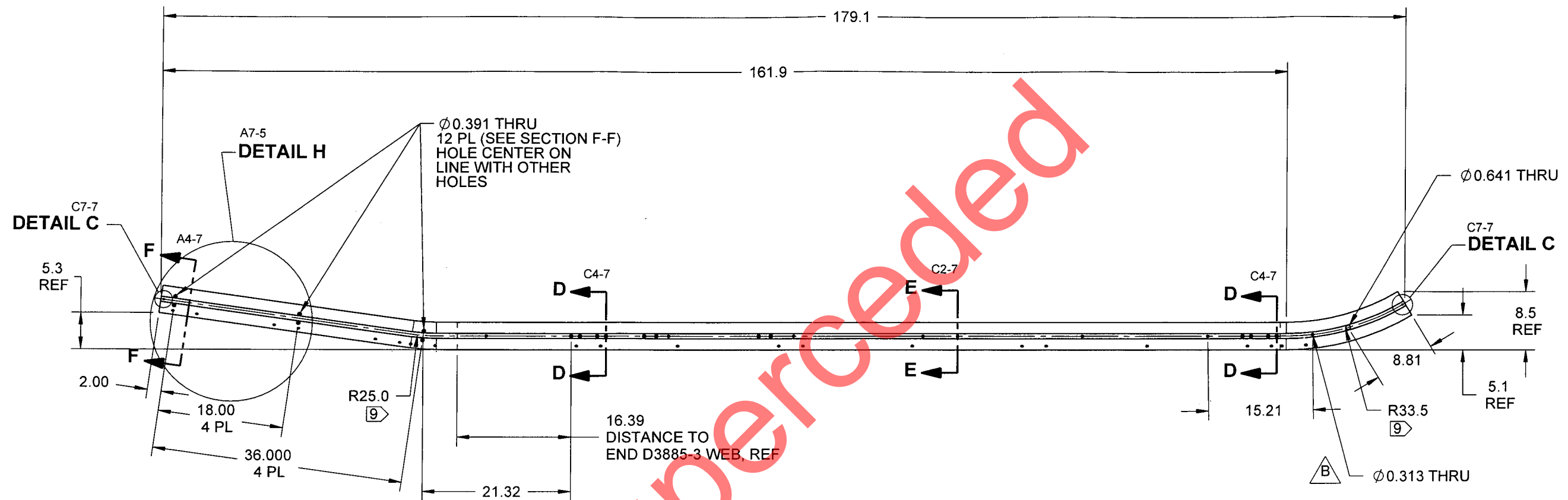


D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
 (MAKE FROM D3905-13 SKIDTUBE)

UNDER REVIEW
 13.02.25 DB

RELEASED
 09/07/15 MB
DEO ATTACHED

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 4 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



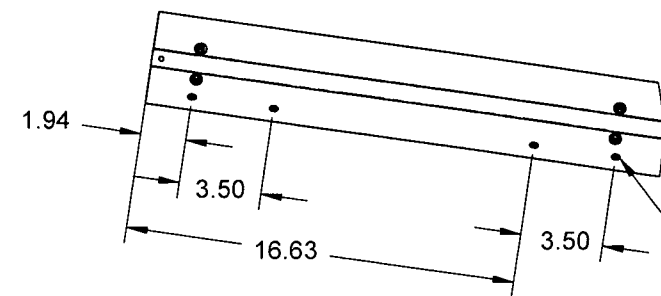
D3905-11 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)

UNDER REVIEW

13.02.25

RELEASED
09/07/15

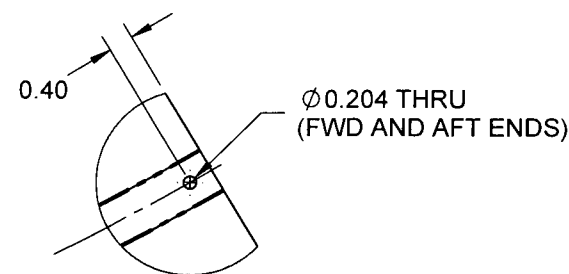
DEO ATTACHED



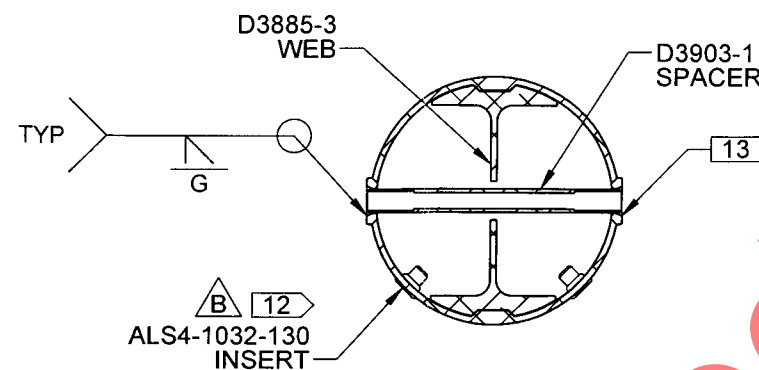
DETAIL H
SCALE 2X C7-5

B
DRILL Ø0.297
INSTALL ALS4-1032-130 INSERT
AFTER FINISH, SEE SECTION F-F
TYP, 2 PL

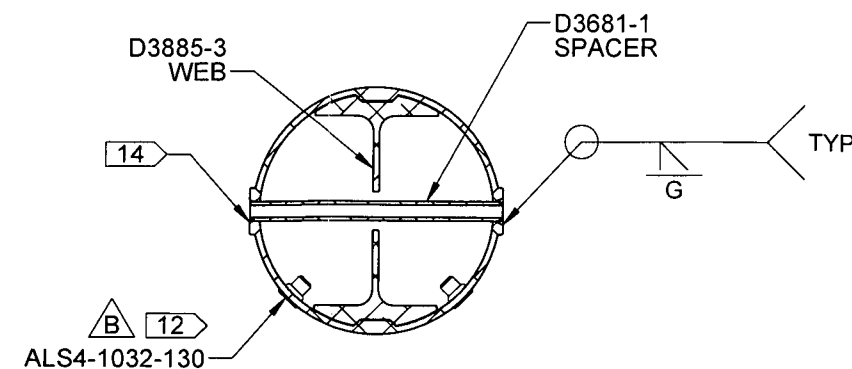
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 5 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



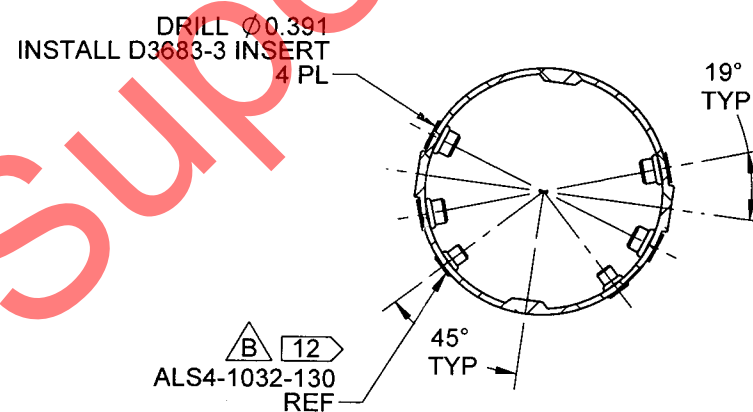
DETAIL C
SCALE 4X
C1-5
C8-5
C8-6
C1-6



SECTION D-D
SCALE 4X
(FOR 12 x Ø0.375 HOLES
PER SKIDTUBE)
C5-5
C2-5
C5-6
C2-6



SECTION E-E
SCALE 4X
(FOR 8 x Ø0.313 HOLES
PER SKIDTUBE)
C4-5
C4-6
B



SECTION F-F
SCALE 4X
C7-6
C7-5

NOTES:

- 13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
- CHAMFER HOLES Ø0.475 x 45° (BOTH SIDES)
 - INSERT D3903-1 SPACER
 - WELD INTO PLACE AND GRIND FLUSH
 - C'BORE TO 0.313 x 0.75 DEEP
 - DEBURR HOLES

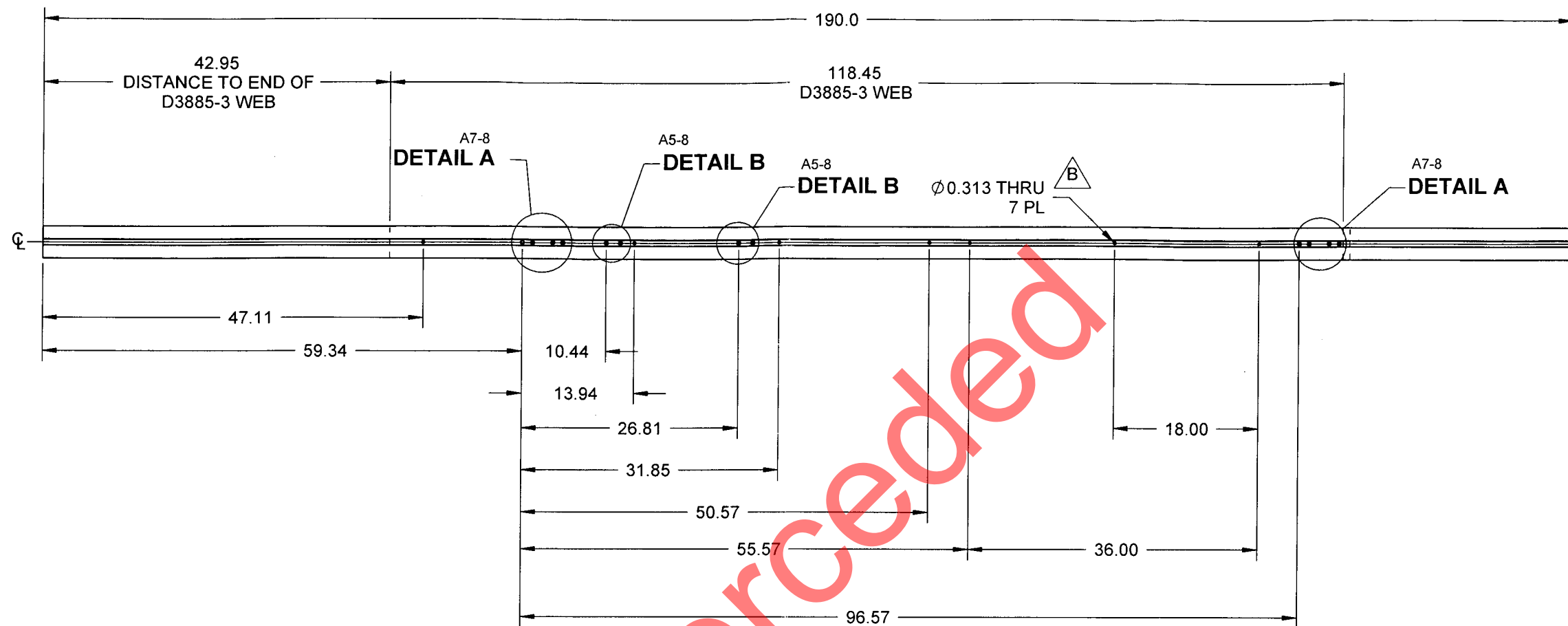
- 14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.313 HOLES ONLY:
- CHAMFER HOLES Ø0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
 - INSERT D3681-1 SPACER
 - WELD INTO PLACE AND GRIND FLUSH
 - DEBURR HOLES

UNDER REVIEW
13.02.25 DB

DEO ATTACHED

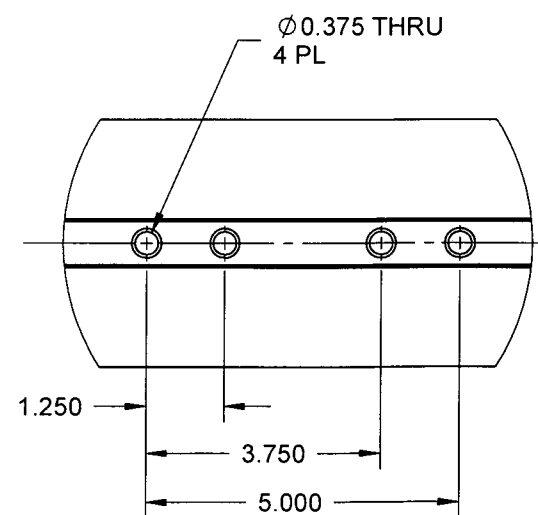
RELEASED
09/07/15 MB

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 7 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

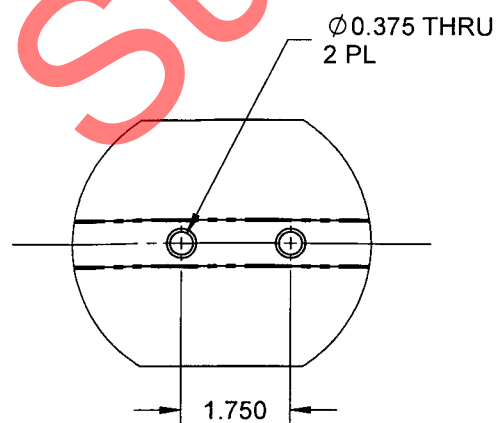


D3905-1 TUBE
(MAKE FROM D2500-1-190 EXTRUSION)

UNDER REVIEW
13.02.25 *AB*



DETAIL A
SCALE 4X
D6-8
D2-8



DETAIL B
SCALE 4X
D5-8
D4-8

DEO ATTACHED
RELEASED
09/07/15 *AB*

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>AB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AB</i>	D3905	SHEET 8 OF 8
APPROVED	<i>AB</i>	TITLE	SCALE
DE APPR.	<i>AB</i>	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

DRAWING NO. D3905	TITLE A119 FLOAT SKIDTUBE ASSY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3905-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>q</i>	MFG. APPR. <i>q</i>	APPROVED <i>q</i>	DE APPR. <i>q</i>		
DATE 12.10.30	DATE 12.10.30	DATE 12.10.30	DATE 12.10.30	DATE 12.10.30	DATE 12.10.30	

PURPOSE:

MODIFICATION OF EXISTING DESIGN TO ALLOW INSTALLATION OF CROSSBOLT SPACERS FOR FORWARD GROUND HANDLING EQUIPMENT.

PARTS LIST:

ADD THE FOLLOWING:

ITEM	QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE

10	2	2	2	D2579	CROSS BOLT SPACER
----	---	---	---	-------	-------------------

ADD THE DRILLING DETAIL BELOW TO DRILLING INFORMATION (SHEETS 5 & 6):

ADD CROSSBOLT SPACER INSTALLATION INFORMATION TO -041 THRU -045 (SHEETS 2 - 4):

DRILL Ø0.500 THRU
CSK Ø0.650 X100°
2 PL PER SIDE

